



# Work Order ID 50001

July 2, 2009 2:56:58 PM



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Item ID: D2873-045  
Revision ID: A  
Item Name: Nut Plate Assembly

Accept



Setup Start



Stop



Start Date: 7/03/09 Start Qty: 20.00

Required Date: 7/08/09 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

⇒ 80767/09

counts  
(440)

0.00

QC

Memo

Quality Control

140

Small Fab

0.00

8/09/07/13 (40)

0.00

Small Fab

Memo

Small Fab

1-Deburr 12- C'sink as per Dwg D2873

150

QC5- Inspect part completeness to step on W/O

0.00

2) 80567/13 counts  
(440)

0.00

QC

Memo

Quality Control

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Cust Item ID:

Required Date: 7/08/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

07-07-13

40

BK.

Memo

0.00

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

09-07-13

40

40

Memo

0.00

180



Small Fab

Small Fab

Small Fab

0.00

0.00

Memo

1-Assemble as per Dwg D2873 2-Identify as D2873-045

09/07/20 40

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Setup Start



Stop



Start Date: 7/03/09 Start Qty: 20.00  
Required Date: 7/08/09 Req'd Qty: 20.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190  
QC  
Quality Control

QC5- Inspect part completeness to step on W/O  
Memo

0.00  
0.00



S 01/07/09

count  
(40)



200  
Packaging  
Packaging

Identify as per dwg & Stock Location: X-tube Assy  
Memo

0.00  
0.00

=> ml 09 07 21 (40)

210  
QC  
Quality Control

QC21- Final Inspection - Work Order Release  
Memo

0.00  
0.00

09/07/22  
mf 09-07-22

# Picklist Print

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Work Order ID: 50001

Parent Item: D2873-045RevA

Parent Item Name: Nut Plate Assembly



Comments:

Start Date: 7/03/09

Required Date: 7/08/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21075L5  Nut Plate		Purchased	No			100	Each	110.0000	40.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	110	
----	-----	--

110916	79	
--------	----	--

111127	31	
--------	----	--

M6061T6B0.375X01.00  
0

Purchased No

180	f	40.1000	4.7368
-----	---	---------	--------



6061T6 BAR .375 x 1.00

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

MAT	40.1	
-----	------	--

105225	5.3	
--------	-----	--

110829	34.8	
--------	------	--

M112243

EB09/07/20

4.7368 DIP 09/07/05

# Picklist Print

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Work Order ID: 50001

Parent Item: D2873-045RevA

Parent Item Name: Nut Plate Assembly



Comments:

Start Date: 7/03/09

Required Date: 7/08/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-6		Purchased	No			180	Each	4,548.000	80.0000			
												
Rivet												

*Ep09/07/20*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4548	
100151	27	
103395	14	
105144	706	
110139	3774	
2525	27	

*160*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

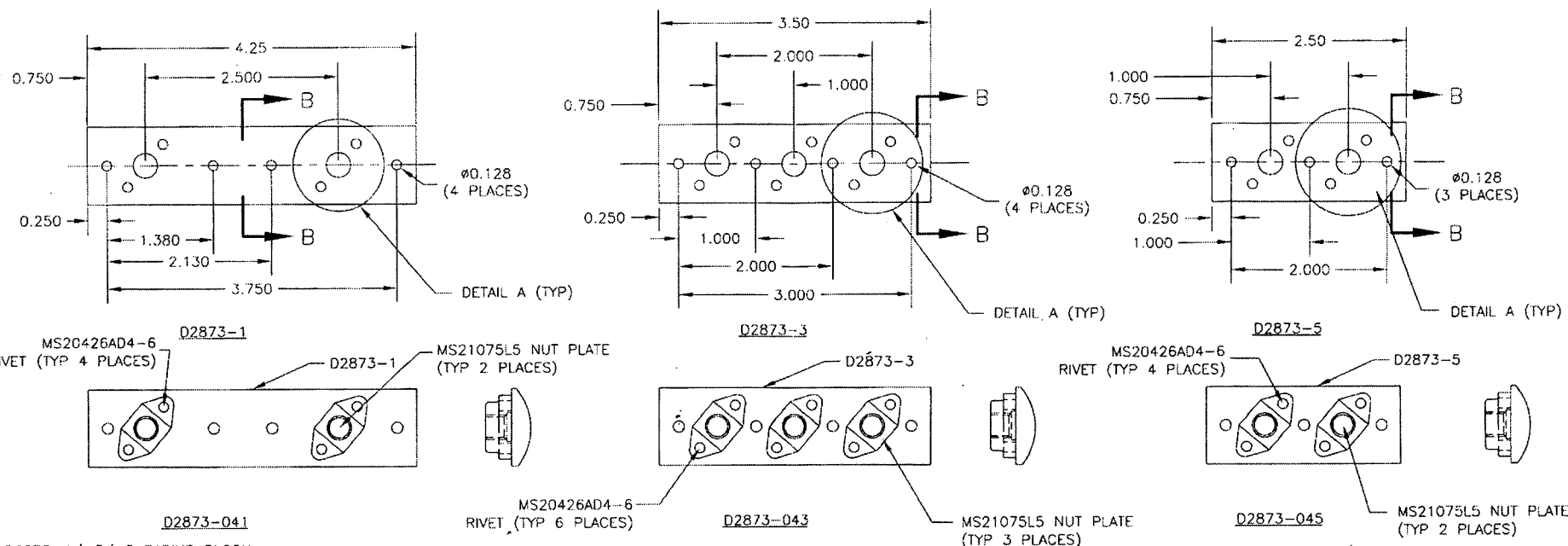
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



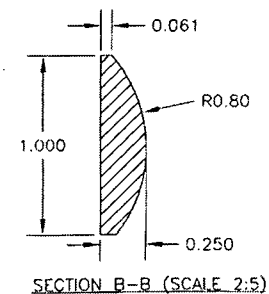
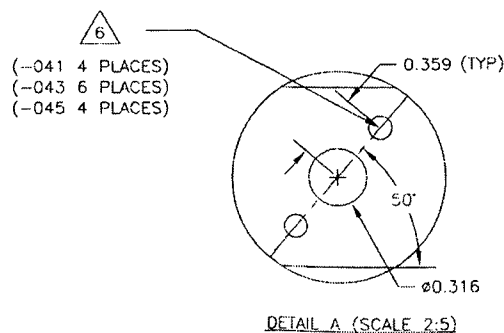




- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR  
6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø.128 PILOT + C'BORE CURVED SIDE Ø.230X0.125 DEEP +  
C'SINK CURVED SIDE Ø.0225 x 100'
- 6

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



A	05.07.26	NEW ISSUE	
DESIGN	PH	<b>DART</b>	DART AEROSPACE LTD WILMINGTON, ONTARIO CANADA
CHECKED	APPROVED	DRAWING NO.	REV. A
DS	DS	D2873	SHEET 1 OF 4
DATE		TITLE	SCALE
05.07.26		RADIUS BLOCK	4:5